

Ship Dec 9 or sooner

Work Order ID 76648

76648

Page 1

November-18-11 10:38:41 AM

Item ID: D3267-043 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Basket Lid Assembly (Inside)
Start Date: 18/11/2011 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 09/12/2011 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: M.L.S. Date: 11/11/11 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3267	Rev C

100 Weld per dwg A/R S.S. rod Batch: M114643 0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-043 as per Dwg D3267

4-Deburr & Remove All Markings From Material

5-Weld D3267-043 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

Pl 11-12-07 1x ~~Ø~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Basket Lid Assembly (Inside)

Stop ***NS2***

Start Date: 18/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00


110

QC

Memo

0.00

Quality Control

 11.12.08

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Sulzlos

~~11.12.08~~

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

130

Powdercoat

Powder Coating

Memo

0.00

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST

START TIME: 8:50

OVEN TEMPERATURE: 400

FINISH TIME: 9:20

***** 2nd coat if necessary *****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

11/12/09

1 11-12-9.

M 119480

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145	Identify as per dwg & Stock Location:	0.00							
145									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

u/12/09

CK 11/12/09

u 11-12-09

W/O:		WORK ORDER CHANGES					
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Picklist Print

November-18-11 10:38:45 AM

Page 1

Work Order ID: 76648

76648

Parent Item: D3267-043

D3267-043

Parent Item Name: Basket Lid Assembly (Inside)

Start Date: 18/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C Removed -041 05-11-04 JLM
IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified
by:EC
IPP Rev:E add I.D. DD 10.03.11 verified by:EC IPP Rev:F
reverse order of seq. 150, 155 DD 10.04.07 Verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-3 *D3166-3* Basket Hoop		Manufactured	No			100	Each	6.0727	0	0			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		6							
				73627		6							
				WA007		0.07270527							
				64928		0.02010527							
				68442		0.0526							
D3182-1 *D3182-1* Hinge		Manufactured	No			100	Each	6.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		6							
				71223		6							
D3442-3 *D3442-3* Shim		Manufactured	No			100	Each	11.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		11							
				70671		11							

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item: D3267-043

D3267-043

Parent Item Name: Basket Lid Assembly (Inside)

Start Date: 18/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

506.7499

7

7.368421

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

Pl 11.11.11

Location

Loc Qty

Loc Code

MAT018

485.0857585

117636

67.9987

118773

417.087059

WA

6.0667

118181

6.0667

WA007

15.5974906

116267

14.628472

116763

0.9690186

7.3684

M304EX0.75-16F

Purchased

No

110

sf

554.2561

4.3

4.526316

M304EX0 75-16F

Expanded Metal Flat SS

**

Pl 11.12.11

Location

Loc Qty

Loc Code

WA

554.2561116

117197

102.9036

117896

53.3264

118153

76.8473

118248

33.0983

118597

21.06788

118955

82.17

119180

184.842632

4.5263

Dart Aerospace Ltd

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QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76648 M.L.J
11/11/18

RELEASED
08-09-18



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT INDICATED AREA PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 3 ADDED. FRAME MATERIAL WALL THICKNESS WAS 0.060. D3267-1 DETAILED.	AJS	08.08.15
B	ADD SHIM UNDER HINGES	PH	05.06.08
A	NEW ISSUE	DS	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3267	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY	NTS
DATE	08.08.15	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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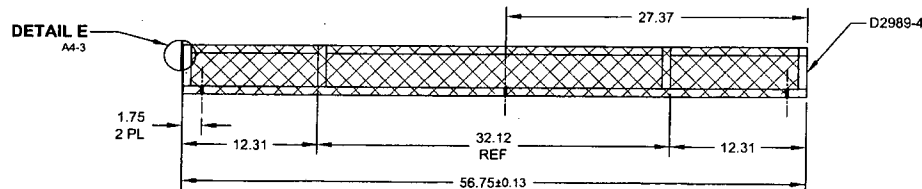
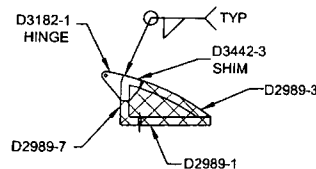
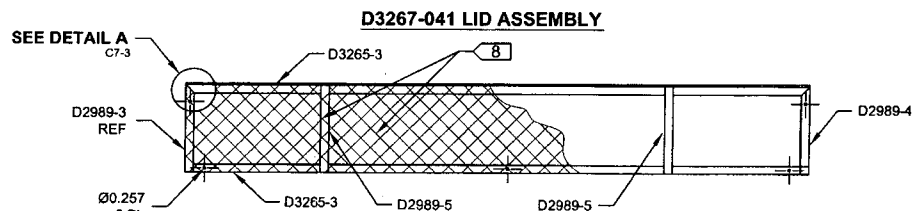
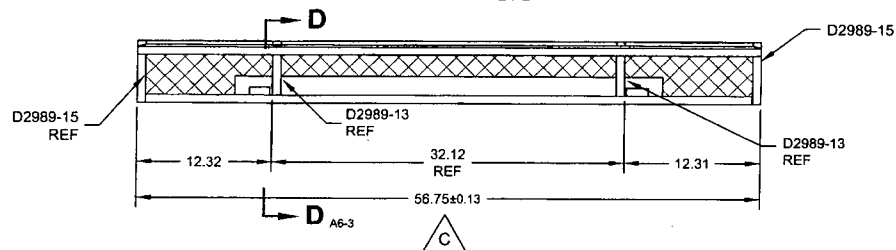
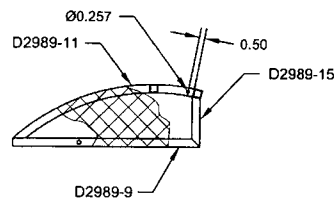
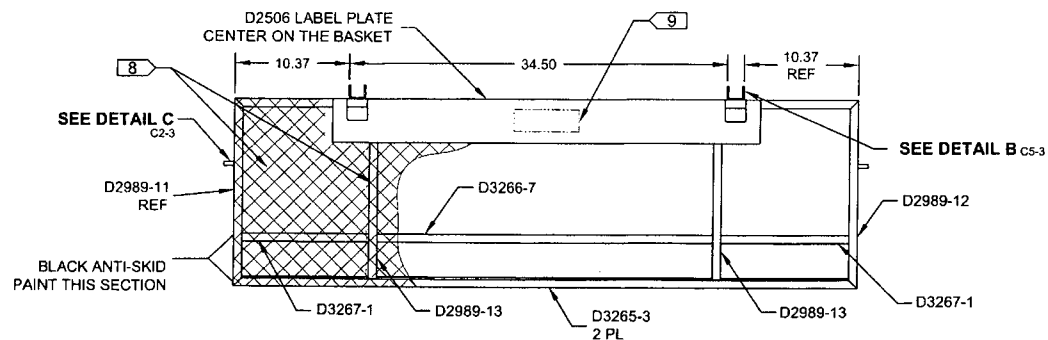
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



76648



NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) SKIN WITH EXPANDED STEEL MESH. TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION.
- 9) REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

D3267-041 LID ASSEMBLY

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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RELEASED
08-09-04/10

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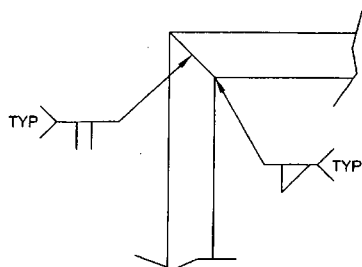
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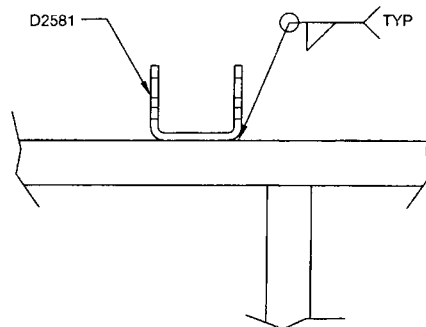
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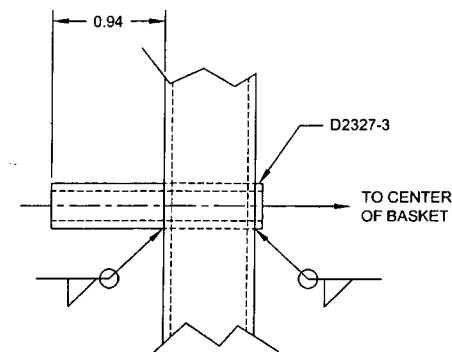
76648



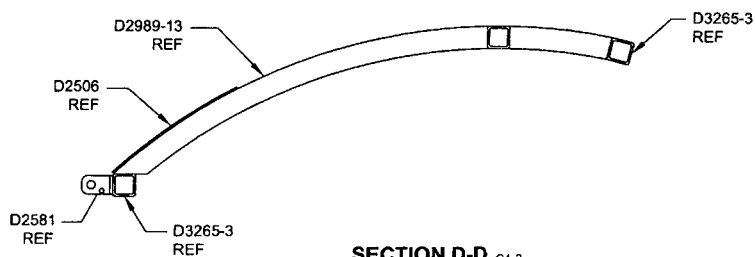
DETAIL A B5-2
JOINT WELD DETAIL TYP
SCALE 2X



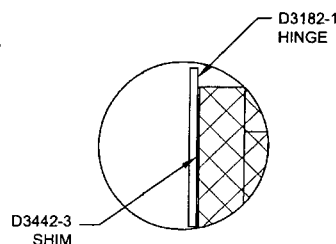
DETAIL B D2-2
2 PL
SCALE 2X



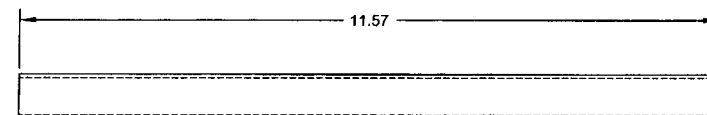
DETAIL C D5-2
SPACER INSTALLATION
SCALE 4X



SECTION D-D C4-2



DETAIL E B6-2
SCALE 2X
2 PL



D3267-1 STRUT
SCALE 2X

RELEASED
08-09-09/10

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED	[Signature]	DRAWING NO.	REV. C
MFG. APPR.	[Signature]	D3267	3 OF 3
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	BASKET LID ASSMEBLY	NTS
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